

Date: 1/8/2007 10:44:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STOP
 Job Number : 30139A
 Estimate Number : 10731
 P.O. Number : N/A Part Number : D23243
 This Issue : 1/8/2007 S.O. No. : J/K Drawing Number : D2324 REV. C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : 28914A Material : N/A
 Due Date : 1/20/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : J. 07.01.08
 Comment : Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K
 J/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X00750 6061-T6 Bar .75" x .75"



Comment: Qty.: 0.5565 f(s)/Unit Total: 11.1300 f(s)

6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

Batch: M102476

J.F. 07/02/27 (22)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (0.75" x 0.75") x 5.75" Long Bar

J.F. 07/02/27 (22)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio D2324-3 and Dwg D2324

2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

MS 07/02/28

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/02/28

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Ep 07/03/01

(22)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:44:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 30139A

Part Number: D23243

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 07/03/02

(22)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

ml 07/03/02 x22

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

P 7/3/02

(20) ml 07/03/02 x20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) 07/03/05

Job Completion



u 07/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

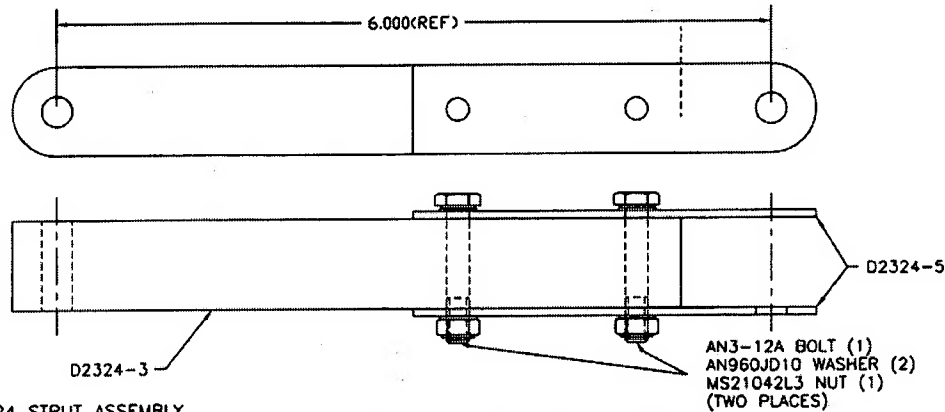
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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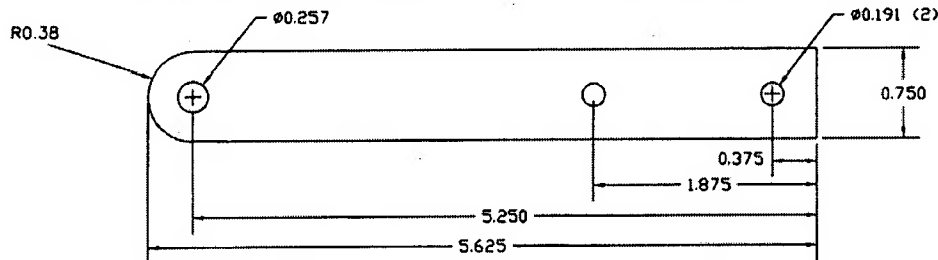
NOTE: Date & initial all entries

DART

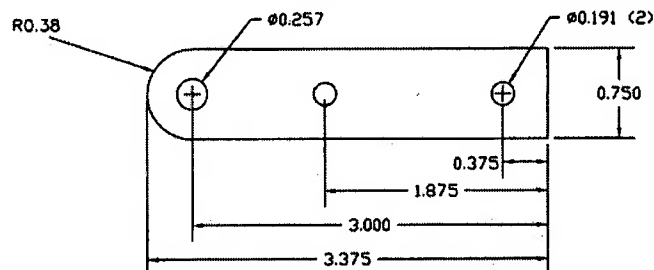
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14	TITLE STRUT	SCALE	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **30139A**